

Split

Work Order ID 136633-2

136633

Page 1

Thursday, September 03, 2015 8:18:26 AM

Item ID: D4711-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Expandable Pin Assembly, Modified

Start Date: 9/1/2015

Start Qty: 6.00

6

Cust Item ID:

Required Date: 9/1/2015

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: MLS

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4711

C

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

120

Small Fab

Small Fab

Memo

ASSEMBLE AS PER DWG (see note 8,9,10)

DO NOT OVERTIGHTEN THE SHAFT INTO THE BARREL PER NOTE 10

0.00

0.00

4 FF NOV 04 2015

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

DAS
38
9-89

NOV 04 2015

Work Order ID 136633

Thursday, September 03, 2015 8:18:26 AM

136633

Page 2

Item ID: D4711-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Expandable Pin Assembly, Modified

Start Date: 9/1/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 9/1/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

Identify as per dwg & Stock Location: GA

0.00

140

Packaging

Memo

0.00

Packaging

4X DAS 28 9-89 NOV 05 2015

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

MCS NOV 05 2015

MCS NOV 05 2015

Picklist Print

Thursday, September 03, 2015 8:18:30 AM

Page 1

Work Order ID: 136633

136633

Parent Item: D4711-041

D4711-041

Parent Item Name: Expandable Pin Assembly, Modified

Start Date: 9/1/2015

Required Date: 9/1/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 12.10.16 AS PER DWG REV.A DD VERF:JFS IPP REV:B
13.03.11 AS PER DWG REV.C DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4711-043		Manufactured	No			110	Each	6.0000	1	6			
D4711-043									**				
Expandable Pin Assembly												27 9-89	

				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST124	6								
				135717	6	B135537							
D4726-1		Manufactured	No		110	Each	2.0000	1	6				
D4726-1								**					
Handle												27 9-89	

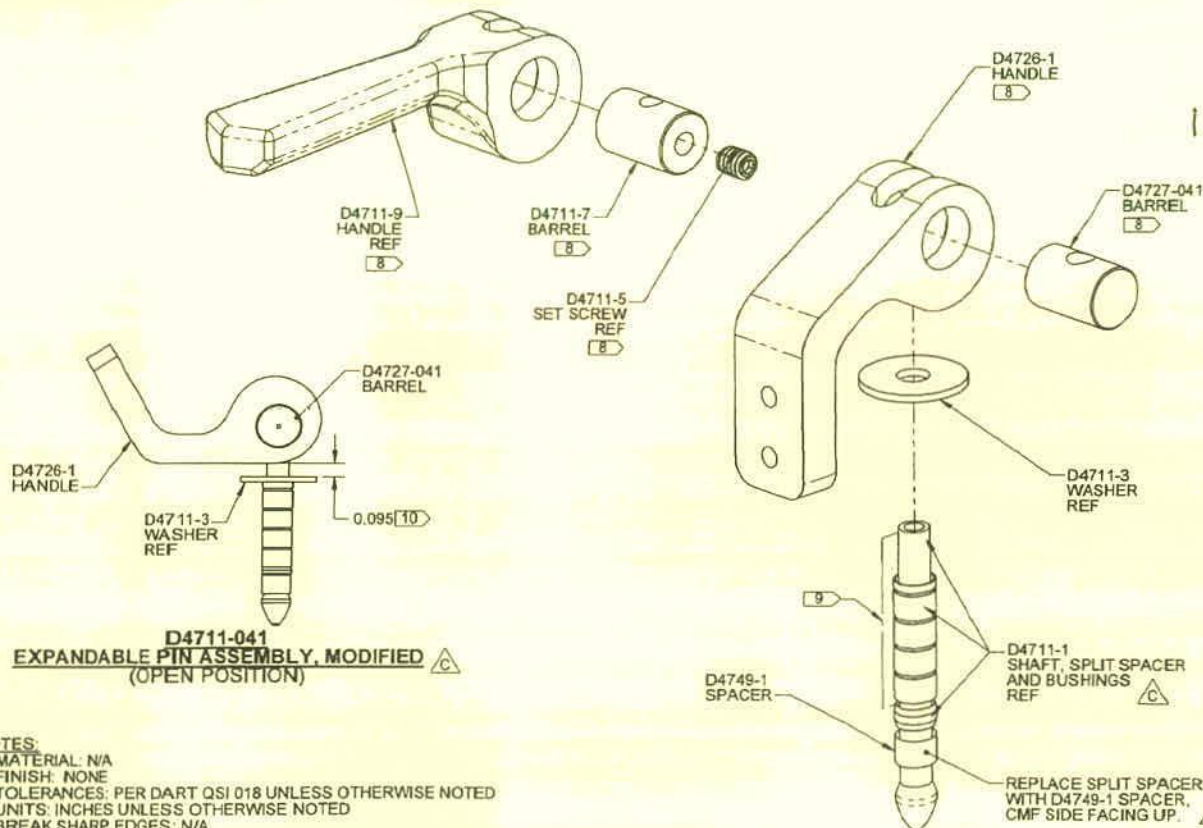
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST125	2								
				134539	2								
D4727-041		Manufactured	No		110	Each	2.0000	1	6				
D4727-041								**					
Barrel												27 9-89	

				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST125	2	B135586							
				134510	2								
D4749-1		Manufactured	No		110	Each	12.0000	1	6				
D4749-1								**					
Spacer												27 9-89	

				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST126	12								
				134892	12								

OCT 01 2015

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4711-041	EXPANDABLE PIN ASSY, MODIFIED
1	1	D4711-043	EXPANDABLE PIN ASSY
2	1	D4726-1	HANDLE
3	1	D4727-041	BARREL
4	1	D4749-1	SPACER



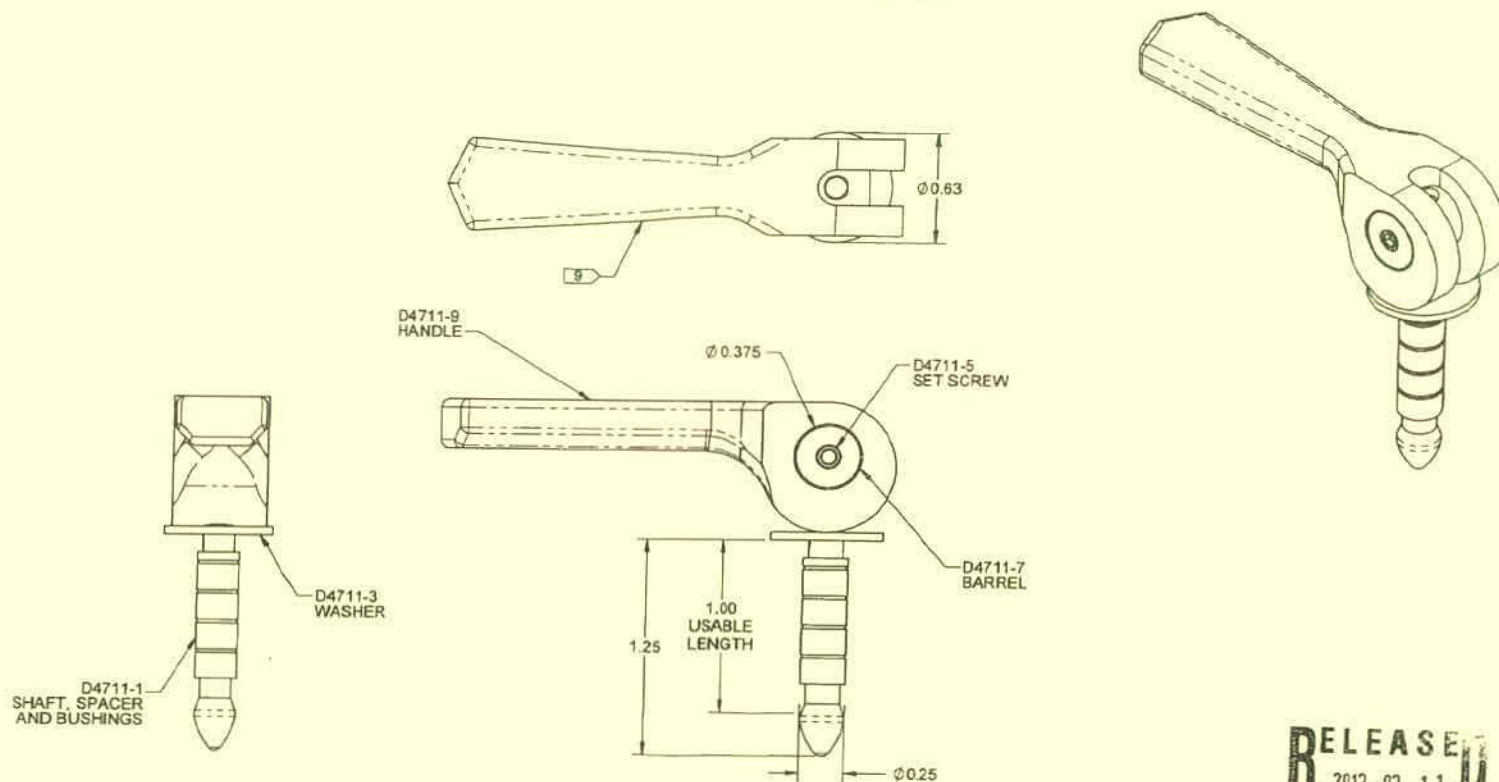
**D4711-041
EXPANDABLE PIN ASSEMBLY, MODIFIED
(CLOSED POSITION)**

RELEASED
2013-03-11

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4711-041" AND B/N "BXXXXX" PER QSI 044 6.7
 - 7) WEIGHT: 0.19 lbs
 - 8) REPLACE D4711-9 HANDLE WITH DART D4726-1 HANDLE.
REPLACE D4711-7 BARREL WITH DART D4727-041 BARREL.
REPLACE BOTTOM SPLIT SPACER WITH D4749-1 SPACER.
DISCARD D4711-5 SET SCREW, D4711-7 BARREL, D4711-9 HANDLE, BOTTOM SPLIT SPACER.
 - 9) WHEN INSTALLING D4749-1 SPACER, ENSURE THAT ALL RETAINED SPLIT SPACERS AND BUSHINGS REMAIN IN THEIR ORIGINAL SEQUENCE AND ORIENTATION.
 - 10) INSTALL THE D4711-1 SHAFT WITH THE ASSEMBLY IN THE OPEN POSITION, UNTIL A GAP OF 0.095" EXISTS BETWEEN THE D4711-3 WASHER AND THE D4726-1 HANDLE. DO NOT OVERTIGHTEN THE SHAFT INTO THE D4727-041 BARREL.

C	REVISED NOTE (A4-1) & NOTE 8. ADDED NOTE 10. PICTORIAL UPDATE. ADDED VIEW B8-1.	AP	13.02.12
B	ADDED D4749-1 SPACER, MODIFIED NOTES 8 AND 9	AP	12.11.23
A	NEW ISSUE	RP	12.09.19
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	ALS	DRAWING NO.	REV. C
MFG. APPR.	AP	D4711	SHEET 1 OF 2
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	ADJUSTABLE DIAMETER PIN	NTS
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SPECIFICATION CONTROL DRAWING



D4711-043 EXPANDABLE PIN ASSY

RELEASE
2013-03-11

NOTES:

- 1) MATERIAL: CORE PIN, SPLIT RINGS & BARREL: STAINLESS STEEL 17-4 PH CONDITION H925 PER AMS 5643
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs
- 8) RECOMMENDED SUPPLIER: MCMASTER CARR P/N 97787A861
- 9) HANDLE, BARREL AND SET SCREW TO BE DISCARDED AT NEXT HIGHER ASSEMBLY

DESIGN	RP	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	SA	D4711	SHEET 2 OF 2
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	ADJUSTABLE DIAMETER PIN	NTS
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